

Date: Tuesday, 22/04/2008 3:53:25 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 38757	
Estimate Number : 12298	
P.O. Number :	Part Number : D34931
This Issue : 22/04/2008 S.O. No. :	Drawing Number : D3493 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 38102	Material :
Written By :	Due Date : 30/04/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 08.4.23</u>	
Comment : Est Rev: A New Issue 06-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1000	Inventory
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Comment: Qty.: 0.0306 f(s)/Unit Total : 0.6111 f(s)
 1.00" 304 ROUND BAR
 (M304R1.000)
 Batch: M107144

(34)

PTO →

MMF 08/04/27

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA626 & Dwg D3493

2-Deburr

JML/MMF 08/04/28

(34)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JML/MMF 08/04/28

(34)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JF 08/04/29

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST 105

JF 08/04/29

(34)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3493-1 PAR #: NA Fault Category: Prod/Machined P/B NCR: Yes No DQA: D Date: 02/05/01
 QA: N/C Closed: D Date: 02/05/02

NCR: 38757		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/28	2	operator graded mat. 303 instead of 304. All parts affected operator reads wrong label (training)	PE per QSS 042 01.04.28	ACCEPTABLE DEVIATION	MMF 08/04/28	C 08/04/28	PE per QSS 042 01.04.28	C 08/04/28

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 38757

Part Number: D34931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

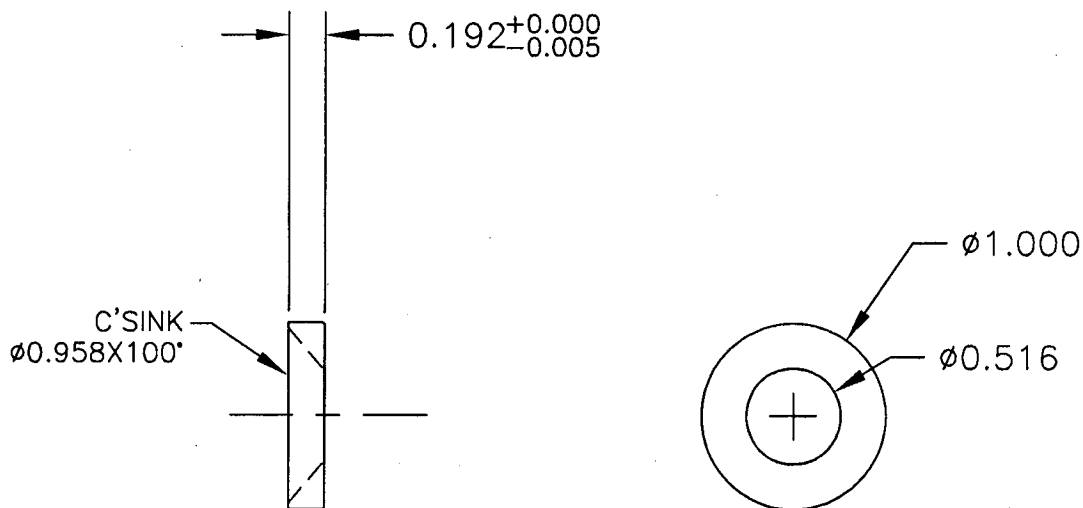
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE WASHER	SCALE 1:1
A	06.01.04	NEW ISSUE	



D3493-1 WASHER

D3493-1 WASHER

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL Ø1.000 ROUND BAR
(REF DART MATERIAL SPEC M304R1.000)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38257

RELEASED
06.02.07 [Signature]

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